

# Work Order ID 59418

Friday, June 04, 2010 9:16:40 AM



Page 1

Item ID: D2230-3

Accept



Setup Start

Revision ID:

Item Name: Lug

Stop



Start Date: 6/4/2010 Start Qty: 160.00



Cust Item ID:

Required Date: 6/10/2010 Req'd Qty: 160.00



Customer:

Reference:

Approvals:

Process Plan: *11*

Date: *10-6-04*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D2230

Rev F

100

0.00



BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut D2423 extrusion to 0.82"  
Batch: *B45800*

*B.A 10/06/10*

*160* *φ*

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1.

Memo

0.00

HAAS CNC vertical machine #1

1-Machine per folio FA927  
FOLIO REV: *G*  
DWG REV: *G*  
Check for crack while loading into the machine.  
2- deburr

*B.A 10/06/11*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 59418**

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Page 2

Item ID: D2230-3

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Item Name: Lug

Start Date: 6/4/2010 Start Qty: 160.00

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00

H.A

10/06/11

QC

Memo

0.00

Quality Control

10.6.12

160

130

QC8- Inspect parts - second check

0.00

10/06/14

QC

Memo

0.00

Quality Control

160

p

150

Chemical Conversion Coat per QSI005 4.1

0.00

HandFinish

Memo

0.00

Hand Finishing

(160), 10-6-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Friday, June 04, 2010 9:16:40 AM



Page 3

Item ID: D2230-3	Accept		Setup Start	
Revision ID:			Stop	
Item Name: Lug				
Start Date: 6/4/2010	Start Qty: 160.00		Cust Item ID:	
Required Date: 6/10/2010	Req'd Qty: 160.00		Customer:	
Reference:				

Approvals:	Process Plan: _____	Date: _____	Tooling: _____	Date: _____	Run Start	
	QC: _____	Date: _____	SPC (Y/N): _____	Date: _____	Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160  QC Quality Control	QC3- Inspect Part Finish  Memo	0.00 0.00		10/06/14		160	9		
170  Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum 11/14841 Memo START TIME: 1:00pm OVEN TEMPERATURE: 320°F FINISH TIME: 1:30pm	0.00 0.00		10/06/15		160	9		
180  QC Quality Control	QC3- Inspect Part Finish  Memo	0.00 0.00				160			BR 10-6-15.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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**NOTE:** Date & initial all entries

**Work Order ID 59418**

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Page 4

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Revision ID:

Item Name: Lug

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Required Date: 6/10/2010 Req'd Qty: 160.00

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Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

190

Identify as per dwg & Stock Location: 476

0.00



Packaging

Memo

0.00

Packaging

10-6-17 SP (160)

200

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/06/17 JF

MEF

10-6-17

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**NOTE:** Date & initial all entries



# Picklist Print

Friday, June 04, 2010 9:16:44 AM

Page 1

Work Order ID: 59418



Parent Item: D2230-3



Parent Item Name: Lug

Start Date: 6/4/2010

Required Date: 6/10/2010

Comments: IPP ☐ D ☐ 00.05.18 ☐ Added inspection level 8, and removed P/O for powder coat ☐ EC  
25 JLM VERIFIED BY:EC  
☐

Start Qty: 160.00

Required Qty: 160.00

D2423

Manufactured No

100 f

461.9047

0.0683

11.50316



Lug Extrusion

Location

Loc Qty

Loc Code

MAT06

461.9046795

43722

180

45800

281.904679

11.5031

B.A 10/06/10

W/O:		WORK ORDER CHANGES					
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

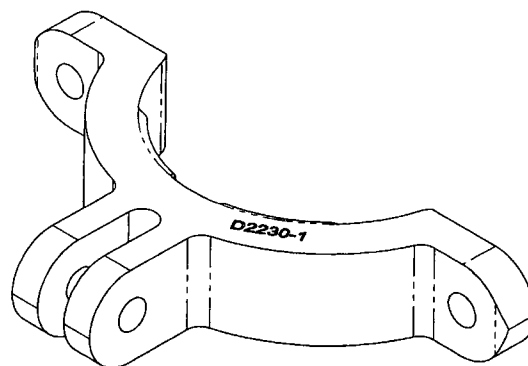
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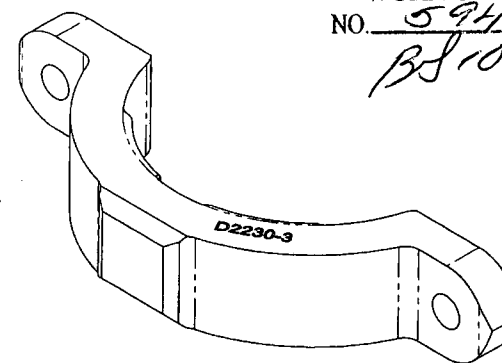
SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT

WITHOUT NOTICE  
WORK ORDER

NO. 59418  
BS10-6-011



**D2230-1 MOUNTING LUG**



**D2230-3 MOUNTING LUG**

**RELEASED**  
*01/06/2016*

**G**

**NOTES:**

- 1) MATERIAL: MAKE FROM D2423 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART NUMBER TO A DEPTH OF 0.010 ± 0.005 IN THIS LOCATION, WITH TOOL TIP RADIUS OF 0.015 ± 0.005.
- 7) WEIGHT: -1: 0.16 lbs  
-3: 0.14 lbs

G	REDRAWN IN SOLIDWORKS TO CURRENT DESIGN STANDARDS. REFER TO SECTION A-A & B-B FILLET ADDED TO PREVENT CHAFING OF RUBBER CUSHION ON INSTALLATION.	AJS	09.01.16
F	REDESIGN: R1.200 WAS 1.100	CP	99.12.13
E	RE-DESIGN	BW	95.01.04
D	RE-DESIGN	BW	95.01.04
C	RE-DESIGN	BW	94.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. G
MFG. APPR.	<i>[Signature]</i>	D2230	SHEET 1 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	MOUNTING LUG	NTS
DATE	09.01.16	COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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**NOTE:** Date & initial all entries

8 7 6 5 4 3 2 1

D

C

B

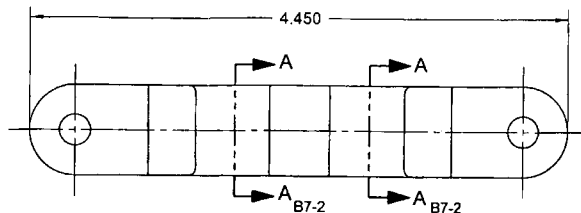
A

D

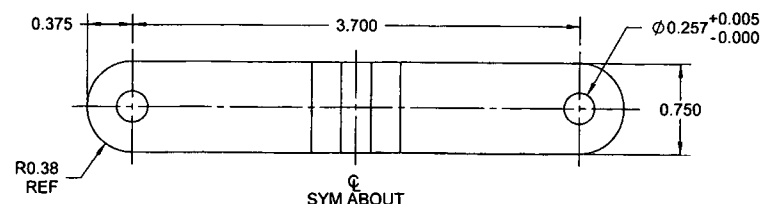
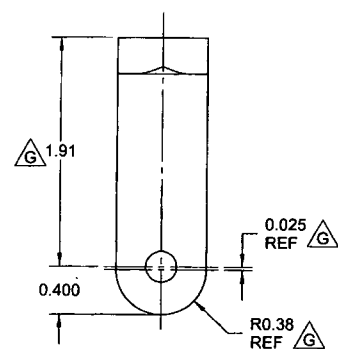
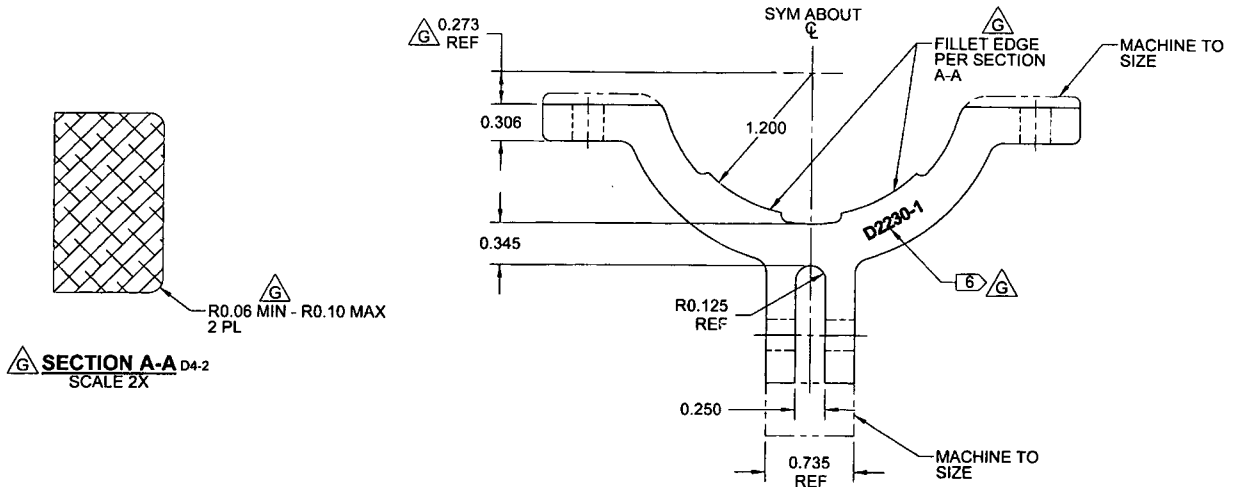
C

B

A



w/o 39418



**D2230-1 MOUNTING LUG**

**RELEASED**  
09/06/75

DESIGN	BW	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D2230	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		MOUNTING LUG	NTS
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8 7 6 5 4 3 2 1

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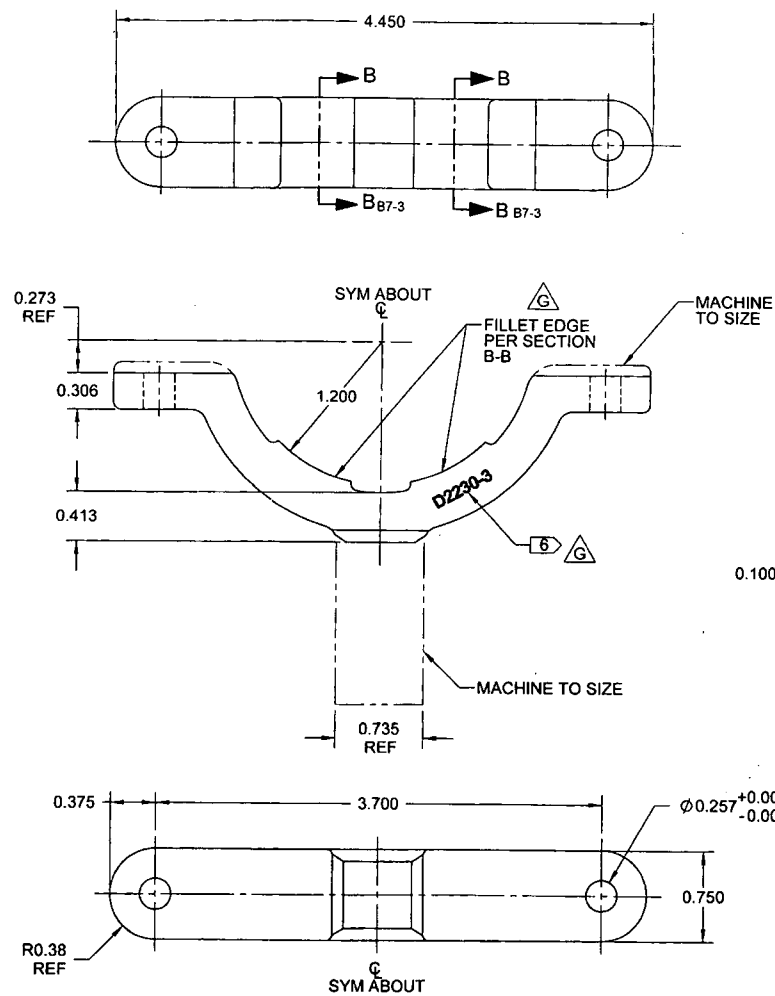
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**NOTE:** Date & initial all entries



**SECTION B-B**  
SCALE 2X

R0.06 MIN - R0.10 MAX  
2 PL



**D2230-3 MOUNTING LUG**

**RELEASED**  
09/06/25

DESIGN	BW	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AS		
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D2230	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		MOUNTING LUG	NTS
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